

PROCESS FOR PREPARING ETHER-CAPPED POLY(OXYALKYLATED)  
ALCOHOL SURFACTANTS  
ABSTRACT OF THE INVENTION

A process for preparing an ether-capped poly(oxyalkylated) alcohol surfactant is provided. The alcohol has the formula:



wherein, R is selected from the group consisting of linear or branched, saturated or unsaturated, substituted or unsubstituted, aliphatic or aromatic hydrocarbon radicals having from about 1 to about 30 carbon atoms; R<sup>1</sup> may be the same or different, and is independently selected from the group consisting of branched or linear C<sub>2</sub> to C<sub>7</sub> alkylene in any given molecule; x is a number from 1 to about 30; and R<sup>2</sup> is selected from the group consisting of:

- (i) a 4 to 8 membered substituted, or unsubstituted heterocyclic ring containing from 1 to 3 hetero atoms; and
- (ii) linear or branched, saturated or unsaturated, substituted or unsubstituted, cyclic or acyclic, aliphatic or aromatic hydrocarbon radicals having from about 1 to about 30 carbon atoms;

provided that when R<sup>2</sup> is (ii) then either at least one of R<sup>1</sup> is other than C<sub>2</sub> to C<sub>3</sub> alkylene or R<sup>2</sup> has from 6 to 30 carbon atoms.